

AMENDMENT TO THE CLAIMS

This listing of claims will replace all prior versions, and listings, of claims in the application:

1-6. (Canceled)

7. (Currently amended) A method for producing a rim hole through first and second planar workpieces wherein the first and second planar workpieces are metal, comprising:

forming a penetration opening through the first and second planar workpieces by translating a first punch in a first direction to a first position;

translating the first punch, in the first direction, from the first position to a second position relative to a fixed matrix;

forming, against a working edge of the fixed matrix, a break away portion in the second planar workpiece;

forming a rim hole having a rim using the first planar workpiece such that the rim is formed adjacent to an inner surface of the matrix; and

forming the rim into a single layer flange engageable with a bottom surface of the second planar workpiece, wherein the flange is formed using a flange punch and the flange punch engages the flange from a second direction that is linearly opposite to the first direction.

8-10 (Cancelled)

11. (Previously amended) The method of claim 7, wherein the first punch has a first working surface to form the penetration opening and a second working surface to form the rim adjacent to the inner surface of the matrix.

12-13 (Canceled).

14. (Previously amended) The method of claim 32, wherein the round penetration hole is formed using a first punch having a transition surface and a body surface.

15. (Previously amended) The method of claims 32 or 33, wherein the transition surface of the first punch engages at least one of the plurality of planar workpieces to promote the separation of the annular break away portion and form an annular rim adjacent to the inner surface.

16. (Previously amended) The method of claims 32 or 33, wherein the annular break away is formed against a working surface of the matrix and an annular rim is formed adjacent to the inner surface of the matrix.

17-21. (Canceled).

22. (Previously presented) The method of claim 7, wherein the flange punch is an oblong flange punch.

23. (Previously presented) The method of claim 7, wherein the penetration opening is an oblong penetration opening.

24. (Previously presented) The method of claim 7, wherein the first punch is an oblong punch.

25. (Previously presented) The method of claim 7, wherein the break away portion is an oblong break away portion.

26. (Previously presented) The method of claim 7, wherein the rim is an oblong rim.

27. (Previously presented) The method of claim 7, wherein the rim hole is an oblong rim hole.

28. (Previously presented) The method of claim 7, wherein the flange punch is a round flange punch.

29. (Previously presented) The method of claim 7, wherein the first punch is a round punch.

30. (Previously presented) The method of claim 7, wherein the rim hole is a round rim hole.

31. (Previously presented) The method of claim 7, wherein the penetration opening is a round penetration opening.

32. (Previously presented) The method of claim 7, wherein the break away portion is an annular break away portion.

33. (Previously presented) The method of claim 7, wherein the rim is an annular rim.

34. (Canceled)

35. (New) A method for producing a rim hole through first and second planar workpieces wherein the first and second planar workpieces are metal, comprising:

forming a round penetration opening through the first and second planar workpieces by first using a circular drill and then by translating a first punch in a first direction to a first position;

translating the first punch, in the first direction, from the first position to a second position relative to a fixed matrix;

forming, against a working edge of the fixed matrix, a break away portion in the second planar workpiece;

forming a rim hole having a rim using the first planar workpiece such that the rim is formed adjacent to an inner surface of the matrix; and

forming the rim into a single layer flange engageable with a bottom surface of the second planar workpiece, wherein the flange is formed using a flange punch and the flange punch engages the flange from a second direction that is linearly opposite to the first direction.